

MODEL            TS630

WOODWORKING GRINDING MACHINE

SERVICE MANUAL

## 1 Usage

This machine can be used for the grinding of straight blade or other kind of blade in woodworking.

It is convenient in operating and high capacity.

It is the necessary equipment for woodworking industry.

## 2 Primary parameter

Max.blade length .....	630 mm
Fence turning angle .....	0°~55°
Blade cutting angle .....	35°~90°
Motor power .....	550W 220V 50Hz
Sandwheel speed .....	2800 r/min
Sandwheel size(D×d×W).....	100× 20× 50 mm
Overall dimensions(L×B×H).....	870×450×1200 mm
Packing size(L×B×H) .....	900×480×460 mm
N.W.....	75kg
G.W. ....	90kg

## 3 Preparation

3.1 Check the main engine and spare parts when you open the packing case, if something wrong, let the seller know.

3.2 The sliding parts are oiled before the machine leaving the factory. Clean it and spray lube before using.

3.3 Mount water box and pipe with the main engine.

3.4 Connect the electric and earthed it dependable according the machine's, quirement.

3.5 wipe the anti-rust oil in sliding slot, then spray lube in the slot, do the same to the other parts.

## 4 Safety rules

4.1 Check the sandwheel to see if there is something wrong.

4.2 Tighten the sandwheel screw as possible but not too tight to prevent the sandwheel crashed.

4.3 Mount the sandwheel hood.

4.4 Earth the machine properly.

4.5 The voltage and frequency must be maching with the machine.

4.6 Cut the mains off before change the sandwheel or maintenance.

4.7 Activate the switch for a fraction of a second and check the sandwheel rotation direction.Should rotation be incorrect, immediately switch off the power and invert two of the three phases on the terminals.

4.8 During the operation. press the blade tighten.

4.9 Wear goggles to prevent the dust damage eyes.

## 5 Operation rules

5.1 Do the safety work well before connect with the mains. Try to start the machine before the

**general operation.**

## 5.2 Operation steps

5.2.1 Mount the blade under the presser and fixed well before start the sandwheel.

5.2.2 Turn the infeed handwheel slightly to make the blade near the sandwheel transversely.

5.2.3 Pull out the sliding plate longitudinally to make the blade separate to the sandwheel, then turn the infeed handwheel about 0.1mm (that's the grinding capacity, pay attention to the grinding capacity.)

5.2.4 After the first time grinding, dismount the blade to check the quality, then adjust the locating plate or angle knob to process the second time grinding.

5.3 Grind the blade separately. No spark before infeeding. After the grinding, finish the blade with oil stone.

5.4 During the operation, drop the cool liquid on the blade.

5.5 After operation, clear the cool liquid to prevent the blade damaged spray oil on the sliding part. If the machine is not used for a long time spray antirust oil.

5.6 Lubricate the sliding part and turning part of the machine.

## 6 Packing list

Liquid box 1;  
Plastic pipe 1;  
Pole 1;  
Special spanner 2;  
Service manual 1;  
Certificate 1;

